

Work Order ID 70148-1

Monday, May 30, 2011 11:23:39 AM

*SPLIT*  
*eps*  
*\$2*



Page 1

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 5/30/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *JMF*

Date: *11-05-30* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

106

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeapex Bandsaw

Cut blanks: 29.125" long

*SL 11/06/02*

*6*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D3197. 2-Machine D3197-1 as per Folio FA340 and Dwg D3197 3-Deburr

*SL 11/06/02*

*6*

120

0.00



QC2- Inspect parts off machine FA/FAIB

QC

Memo

0.00

Quality Control

*SL 11/06/02*

*6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

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Item ID: D3197-041

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Lathe Conv

CONVENTIONAL LATHE

0.00

Conventional Lathe

Memo

Chamfer as per Dwg D3197

0.00

32 11/06/02

6 10

140



QC

QC8- Inspect parts - second check

0.00

Quality Control

Memo

0.00

2 11/06/02

6 10

150



Hand Finish

Chemical Conversion Coat per QS1005 4.1

0.00

Hand Finishing

Memo

0.00

6 11/06/02

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Setup Start



Revision ID:

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Item Name: Bar Assembly

Start Date: 5/30/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Grey Sandtex(Ref:4.3 5 6) per QSI005 4 3

0.00



Powdercoat

Memo

START TIME

FINISH TIME:

0.00

OVEN TEMPERATURE:

Powder Coating

9:30

3:20

10:00

6 x 8 m/11/06/02

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 x 8 m/11-6-2

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3197-041 as per Dwg D3197

6/5/06/02 @2



W/O:		WORK ORDER CHANGES					
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Page 1

Parent Item Name: Bar Assembly

Required Date: 6/10/2011

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10  Washer	NAS1149D0363J	Purchased	No			180	Each	0.0000	6	24			
D2690-5  Lanyard Assembly		Manufactured	No			180	Each	11.0000	2	8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST020			11						
					66820		11						
D3242-1  Tag		Manufactured	No			180	Each	4.0000	2	8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST044			4						
					65390		4						
D3489-3-200  PIP PIN		Manufactured	No			180	Each	9.0000	2	8			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			9						
					68563		9						

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 70148

Parent Item: D3197-041

Parent Item Name: Bar Assen:bly



Start Date: 5/30/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

M7075T73R1.000 Purchased

No

180

1

30 8650

2.42

12.1



7075-T73 Rd Bar 1.00



SL 11/06/02

## Location

## Loc Qty

## Loc Code

MAT012

30 865

115165

2 7

116405

4 54

116604

2 25

116835 \*

12

116962 x2

9.375

9.68  
4.84

MS210421.3

Purchased

No

180

Each

2,119.000

2

8



Nut



ES 11/06/02

## Location

## Loc Qty

## Loc Code

ST300

2119

116391

11

116540

142

116549

766

117441

800

117601

400

24

MS27039-1-24

Purchased

No

100

Each

122.0000

2

8



Screw



ES 11/06/02

## Location

## Loc Qty

## Loc Code

ST292

122

100151

122

24

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Shop Packet Print

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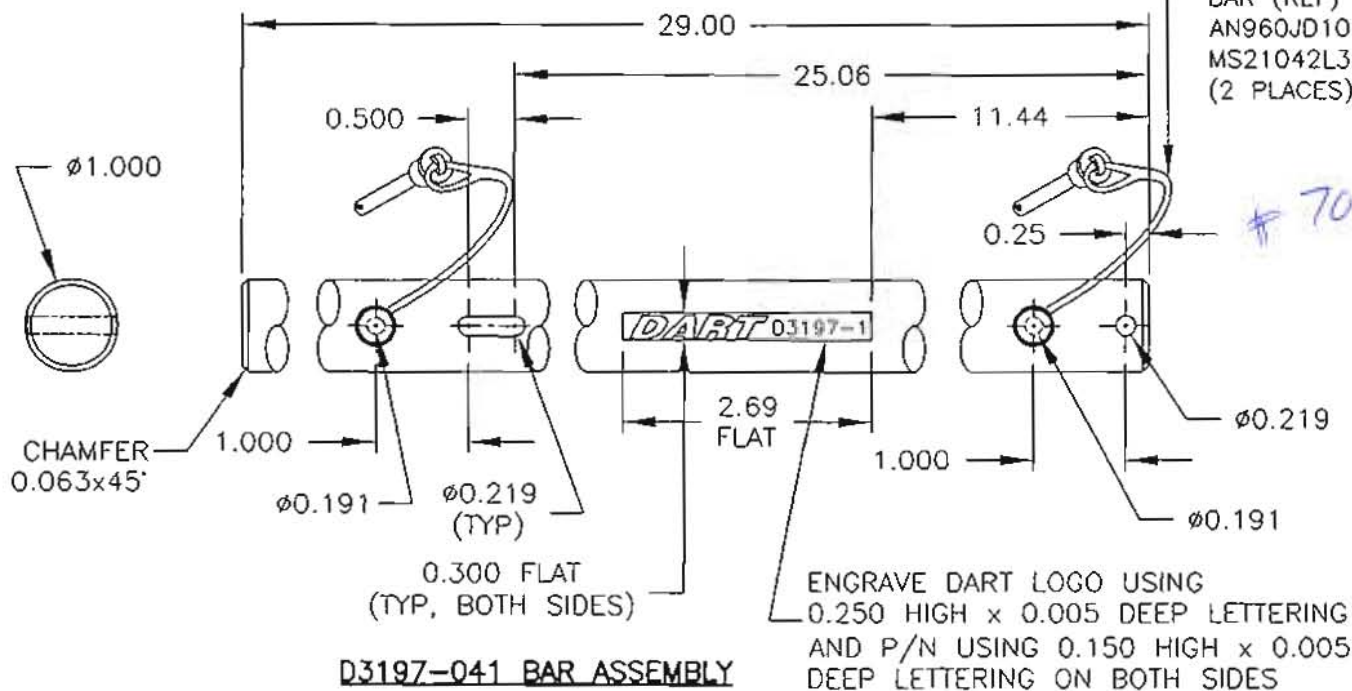
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RELEASED

**DART**

- D3489-3-200 PIP PIN (1)
- D3242-1 TAG (1)
- MS27039-1-24 BOLT (1)
- AN960JD10 WASHER (1)
- D2690-5 LANYARD (1)
- AN960JD10 WASHER (1)
- BAR (REF)
- AN960JD10 WASHER (1)
- MS21042L3 NUT (1)
- (2 PLACES)



### D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D.  
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
		DRAWING NO.	D3197	SHEET 1 OF 1
		SCALE	1:1	
		CHG PIP PIN: ADD D3242-1 TAG		
		NEW ISSUE		
		03.07.01		
		06.01.10		



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